

Split

MOD

Work Order ID 149399-2

149399

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July 22, 2016 3:11:09 PM

Item ID: D3592-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 9/9/2016 Start Qty: ~~25.00~~

25 50 5H

Cust Item ID:

Required Date: 9/15/2016 Req'd Qty: 25.00

25 50 5H

Customer:

Reference

Approvals

Process Plan: SH

Date: 7/25/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3592	Rev B
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100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.17

1-Cut as per Dwg D3592

*****ENSURE GRAIN IS AT 45 DEG AS PER DEO D3592-b-1*****

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

50

see file 107/31

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.04

50

see file 107/31

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1 49399

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Plate

Start Date: 9/9/2016 **Start Qty:** 25.00

25

Cust Item ID:

Required Date: 9/15/2016 **Req'd Qty:** 25.00

25

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

120

QC	Memo	0.08
----	------	------

Quality Control

130	0.02
-----	------

130

Small Fab	Memo	0.25
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Small Fab Form as per Dwg D3592 using DT8949

DAS
30
9-88

30

OCT 19 2016

140	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

140

QC	Memo	0.08
----	------	------

Quality Control

DAS
43
9-89

30.

OCT 19 2016

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Item ID: D3592-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: Plate

Start Date: 9/9/2016

Start Qty: 25.00

25

Cust Item ID:

Required Date: 9/15/2016

Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.04

Packaging

*** STOCK IN STEP CELL ***
LOCATION: WA003

30x

DAS
43
9-89

OCT 19 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.42

Quality Control

DAS
21
9-89

OCT 19 2016

DAS
21
9-89

OCT 19 2016

Picklist Print

Page 1

July 22, 2016 3:11:08 PM

Work Order ID: 149399

149399

Parent Item: D3592-1

D3592-1

Parent Item Name: Plate

Start Date: 9/9/2016

Required Date: 9/15/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A New Issue 07-03.26 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	46.8300	0.139	3.657895			

M6061T6S 125

Dec 16 / 07 / 31

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT020

46.83

m134696

32

m134982

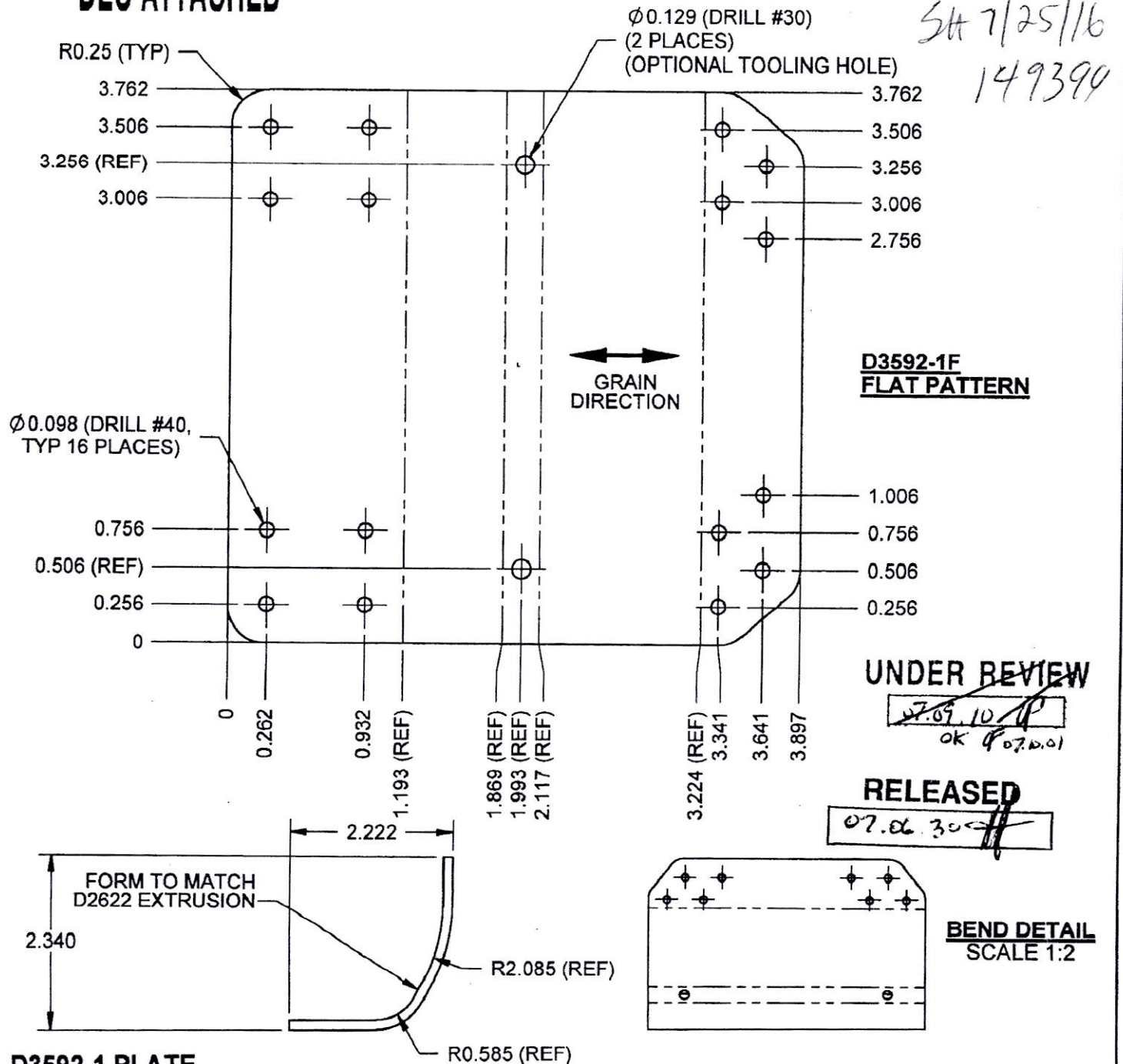
14.83

9.5



DESIGN 9P	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 9P	APPROVED [Signature]	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31	TITLE PLATE		SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

DEO ATTACHED



D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

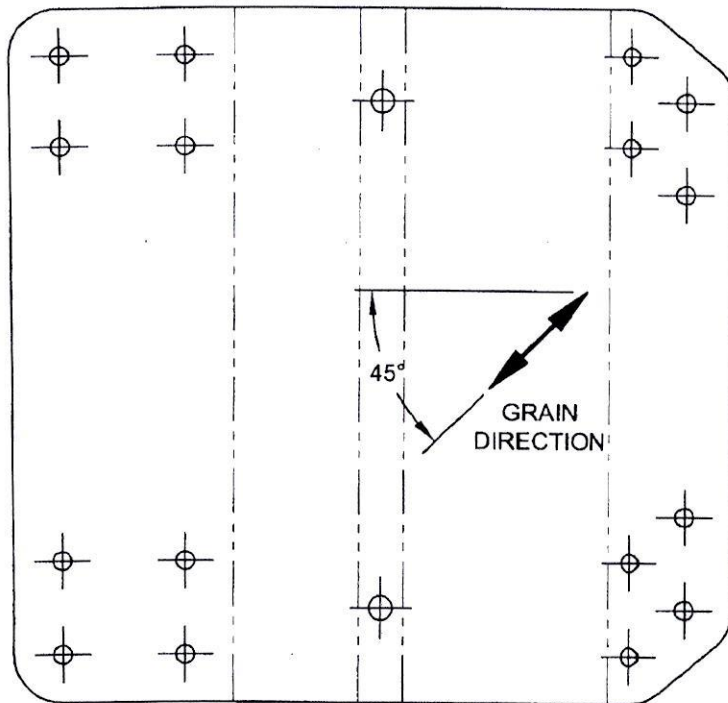
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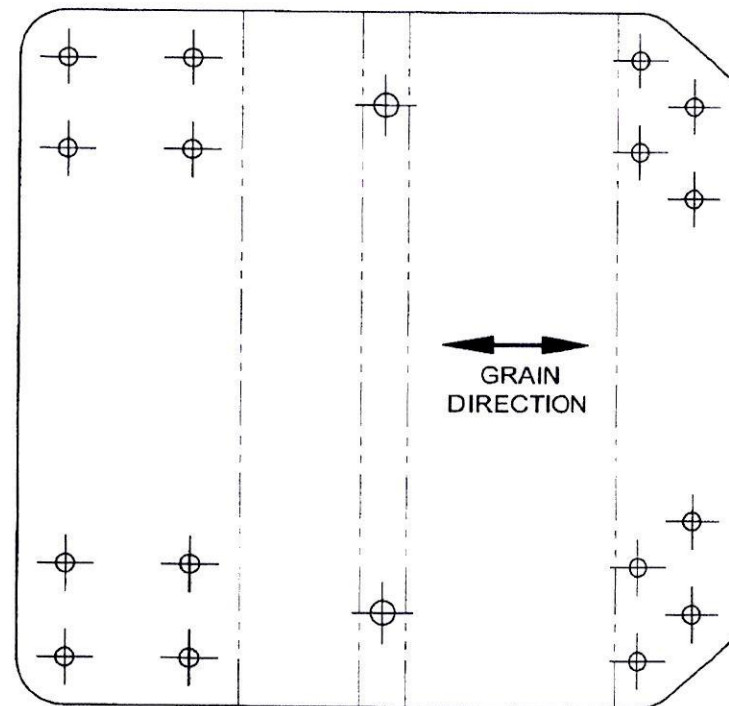
DF	ING NO.	TITLE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO.	SHEET NO.	SCALE
D	02	PLATE				D3592-B-1	SHEET 1 OF 1	NTS
DF	N	AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.	
DA	08.09.11	DATE	08.09.11	DATE	08/09/11	DATE	08/09/11	DATE

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

S:



WAS:



ALL OTHER INFORMATION REMAINS UNCHANGED

RELEASED
08.09.17/18